Monday, 18/09/2006 7:15:00 AM

User:

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 28629

Estimate Number

: 11041

P.O. Number This Issue

Prsht Rev.

:NIA

: 18/09/2006

S.O. No. : NA

: NIA

First Issue : 27617 Previous Run

Written By

Checked & Approved By Comment

: Est C 02.03.07 Now turned in house

Туре

: MACHINED PARTS

Part Number

Drawing Name

: D2809

Drawing Number

- D2809 REV A1 : N/A

: BUSHING

Project Number Drawing Revision

:NIA Material

: 18/09/2006 **Due Date**

Qty:

12 "Um:

Each

Additional Product

Job Number:



Seq. #:

Description:

1.0

M6061T6R0500

6061-T6 Round Bar .500"



0.1045 f(s)/Unit Total: 1.2537 f(s)

6061-T6 Round Bar .500"

Material: 6061-T6 (QQ-A-250-11) rod .500"Ø

Batch: MO142

2.0

HARDINGE

Comment: Qty.:

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA204



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK

09/18

Comment: SECOND

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & deburr all sharp edges as per dwg



06/09/19

Dart Ae	rospace Li	td		·					
W/O:			WORK ORDER C	HANGES		· N			
DATE	STEP	PROCEDURE CHANGE By Date Qty				Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Category:	NCR	R: Yes (No) DQ	A:	ሺ Date:⊘	6/5/15
					QA: N	/C Close	d:	_ Date: _	
NCR:		,	WORK ORDER NON-CONF	ORMANCE	(NCR	2)			
DATE	OTED	Description of NC	Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Action Descr	iption	Sign &	Socti		Chief Eng	OC Inspector

NCR:		,	WORK ORD	ER NON-CONFORMANO	CE (NCR)							
DATE		Description of NC		Corrective Action Section B		Verification	Approval	Approval				
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
							A.					

NOTE: Date & initial all entries

Monday, 18/09/2006 7:15:00 AM Date: Linda Lacelle User: **Process Sheet Drawing Name: BUSHING** Customer: CU-DAR001 Dart Helicopters Services Part Number: D2809 Job Number: 28629 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 7.0 POWDER COATING 4.3.51 Comment: POWDER COATING Powder coat i per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 PACKAGING RESOURCE #1 PACKAGING 1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion



Dart Aerospace Ltd

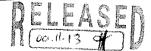
W/O:			W	ORK ORDER CHA	ANGES					
DATE	STEP	PRC	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,			
		;								politica M
Part No	:	PAR #:	Fault Cate	egory:	NCR	: Yes I	No DQA	۸:	_ Date: _	
						QA: N/	C Closed	l:	Date:	
NCR:	,	V	WORK ORE	ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Descript Chief Eng	tion	Sign & Date	Section	on C	Chief Eng	QC Inspector
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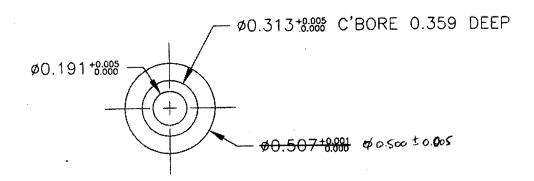
NOTE: Date & initial all entries

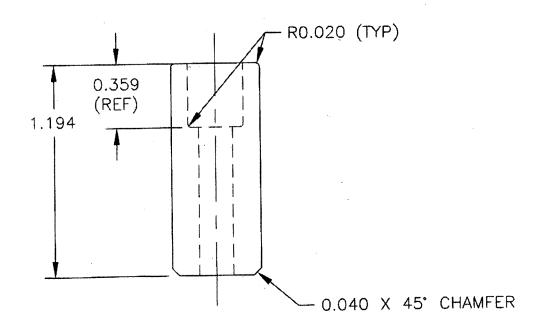




DESIG	A .	ORAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECK	(ED P	APPROVED	DRAWING NO. D28,09 SHEET		V. OF	
DATE		1	TITLE	S	CAI	LE
00.1	1.07		SPACER -	,,,,,,,,,,,	2	2:1
 Α		.00.11.07	NEW ISSUE			
A	A R	07.04.26	ADD POWDER CONT: do. COO WAS do. COT			







TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020 MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

FOWDER COAT WHITE (43.5.1) OR GHEY SANDTEX (43.5.6) OR BLACK SANDTEX (43.5.7) OR GREEN SANDTEX (43.5.8)

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DART AEROSPACE LTD	Work Order:	
Description: Spacer	Part Number:	D2809
Inspection Dwg: D2809 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.000	192			·	
Ø0.313	+0.005/-0.000	.316			, , , , , , , , , , , , , , , , , , , ,	
Ø0.500	+/-0.005	.500				
0.359	+/-0.010	.359				
1.194	+/-0.010	1.195	/			
0.040 x 45°	+/-0.010	.040				
R0.020	+/-0.010	.015	/			
				~		
			·			

Measured by: 5)	Audited by:		Prototype Approval:	N/A
Date: 06/09/18	Date:	06/08/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.04.26	New Issue	KJ/JLM	